



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200
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D4093-3

Job Sheet 185833



Part No: D4093-3

Job Qty: 20 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/4/18

Job Tracking No:

Due Date: 11/19/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEETS 3,4 IPP REV:A NEW ISSUE 10-10-04 JLM VERIFIED BY:DD IPP REV:B AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD IPP REV:B AS PER REV C 11.09.28 JLM VERIFIED BY:DD IPP REV:C 12.10.31 AS PER DWG REV.C DD VERF:JLM *use 316 DTW120

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	20 pcs	11/19/18	11/19/18	0.00	7.66	Waterjet - Flow	OMAX	DA 18/11/18
130	Mill Conv	20 pcs	11/19/18	11/19/18	0.00	10.99	Mill Conv 1		DA 18/11/18
135	QC	20 pcs	11/19/18	11/19/18	0.00	0.00	QC8		DA 18/11/18
140	HandFinish	20 pcs	11/19/18	11/19/18	0.00	0.96	HandFinish1		DA 18/11/18
160	QC	20 pcs	11/19/18	11/19/18	0.00	0.00	QC7-3		DA 18/11/18
170	Packaging	20 pcs	11/19/18	11/19/18	0.00	0.00	Packaging3	ST449 00	DA 18/11/18
180	QC21-SA	20 Ea	11/19/18	11/19/18	0.00	0.00	QC21		DA 18/11/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X06.000	6061T6 Bar .750 X 6.00	11.6000 ft (.58 ea)	110-Waterjet - Flow - 1	S047297

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M6061T6B0.750X06.000	12	9	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	1.050Inches ± 0.030	1.080 1.020		
2	Bracket	3.850Inches ± 0.030	3.880 3.820		
3	Bracket	5.030Inches ± 0.030	5.060 5.000		
4	Bracket	0.380Inches ± 0.030	0.410 0.350		
5	Bracket	0.500Inches ± 0.030	0.530 0.470		
6	Bracket	4.820Inches ± 0.030	4.850 4.790		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

7	Bracket	1.790Inches $\pm$ 0.030	1.820 1.760	
8	Bracket	0.380Inches $\pm$ 0.030	0.410 0.350	
9	Bracket	0.310Inches $\pm$ 0.030	0.340 0.280	
10	Bracket	4.200Inches $\pm$ 0.030	4.230 4.170	
11	Bracket	7.030Inches $\pm$ 0.030	7.060 7.000	
12	Bracket	0.750Inches $\pm$ 0.010	0.760 0.740	
13	Bracket	0.380Inches $\pm$ 0.030	0.410 0.350	
14	Bracket	1.130Inches $\pm$ 0.030	1.160 1.100	
15	Bracket	0.130Inches $\pm$ 0.030	0.160 0.100	
16	Bracket	1.130Inches $\pm$ 0.030	1.160 1.100	
17	Bracket	0.130Inches $\pm$ 0.030	0.160 0.100	
18	Bracket	0.080Inches $\pm$ 0.004 - 0.001	0.084 0.079	Diameter
19	Bracket	0.500Inches $\pm$ 0.010	0.510 0.490	
20	Bracket	1.500Inches $\pm$ 0.010	1.510 1.490	
21	Bracket	2.530Inches $\pm$ 0.010	2.540 2.520	
22	Bracket	1.500Inches $\pm$ 0.010	1.510 1.490	
23	Bracket	0.201Inches $\pm$ 0.005 - 0.001	0.206 0.200	Diameter
24	Bracket	2.390Inches $\pm$ 0.030	2.420 2.360	
25	Bracket	0.201Inches $\pm$ 0.005 - 0.001	0.206 0.200	Diameter
26	Bracket	0.370Inches $\pm$ 0.010	0.380 0.360	Countersink
27	Bracket	100.000Degrees $\pm$ 0.500	100.500 99.500	Angle

Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S126250

Part: D4093-3

Job No: 185833

Serial No/Batch: S126250

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/08/18

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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